

**LISTING OF CLAIMS**

This listing of claims will replace all prior versions, and listings, of claims in the application:

Claims 1-45 (Cancelled)

46. (Currently Amended) A method for manufacturing a storage device for plate-shaped data carriers, said storage device having a first and a second cover pivotally connected, and having an authentication means ~~m02940355~~means, comprising:

positioning an authentication means in a mold for injection molding one of said first and second covers such that said authentication means provides a surface against which injected plastic is molded, said authentication means comprising a printing provided on a carrier; and

injection molding plastic against or around said authentication means in said mold, such that said authentication means cannot be removed from said first or second cover without damaging said authentication means and/or said first or second cover, and wherein said printing forms an integral part of said first or second cover formed in said mold, and wherein said carrier burns or sublimes, while the printing is incorporated on or into the plastic when said plastic is injected into said mold.

47. (Canceled)

48. (Previously Presented) A method according to claim 46, further comprising supplying said carrier in a roll, and cutting a portion for placement in said mold before placing said portion in said mold.

49. (Previously Presented) A method according to claim 46, wherein said printing is designed as a transfer.

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50. (Canceled)

51. (Previously Presented) A method according to claim 46, wherein said printing further comprises providing a holographic printing.

52. (Previously Presented) A method according to claim 46, wherein said printing further comprises providing a bar-code.

53. (Previously Presented) A method according to claim 46, wherein said carrier is provided in said mold, having a printing on two sides, said plastic being provided against said carrier and undetachably connected thereto.

54. (Previously Presented) A method according to claim 53, wherein said carrier is at least partially transparent.

55. (Previously Presented) A method according to claim 46, wherein said authentication means is a magnetic and/or electronic means which is positioned on a carrier in the mold, and injecting plastic around the magnetic and/or electronic means, such that said carrier is enclosed or incorporated therein or disappears therein through burning or sublimation.

56. (Previously Presented) A method according to claim 46, further comprising providing a mold cavity in said mold for forming a fixing means within said storage device for fixing said plate shaped data carrier in said storage device.

57. (Previously Presented) A method according to claim 56, wherein said mold cavity for forming said fixing means in said first or second cover part is provided for holding a CD.

58. (Previously Presented) A method according to claim 56, wherein said mold cavity further comprises providing a surface for forming resilient fingers in said storage device for holding said data carrier in place.

59. (Previously Presented) A method according to claim 46, further comprising:  
providing said carrier in a roll for feeding into said mold;  
providing a frame for positioning a portion of said carrier containing said authentication means in said mold;  
positioning said portion of said carrier on said frame;  
positioning said frame holding said portion of said carrier in said mold against a sidewall of said mold; and  
removing said frame from said mold prior to injecting said plastic.

60. (Previously Presented) A method according to claim 59, wherein further comprising cutting said portion of said carrier containing said authentication means from said roll prior to positioning said portion of said carrier onto said frame.

61. (Previously Presented) A method according to claim 60, wherein said mold further comprises forming the first and second covers in one piece with an integrated hinge to allow for a one piece storage device.

62. (Previously Presented) A method according to claim 61, further comprising providing a hinge cavity in said mold for forming an integrated one piece hinge between said first and second covers.

63. (Previously Presented) A method according to claim 60, wherein said plastic further comprises providing said plastic for injection molding with a melt of at least 30.

64. (Previously Presented) A method according to claim 60, wherein said plastic further comprises providing said plastic for injection molding with a melt of at least 50.

65. (Previously Presented) A method according to claim 46, wherein said injection molding plastic further comprises forming a transparent first or second cover for viewing said authentication means.

66. (Previously Presented) A method according to claim 65, wherein said authentication means further comprises providing a two-sided printing that is viewable from an inside surface and an outside surface of said first or second cover part.

67. (Canceled)

68. (Previously Presented) A method according to claim 46, further comprising providing an electronically readable form related to said data carrier as said authentication means.

69. (Previously Presented) A method for manufacturing a product comprising a compact disc (CD) or digital video disc (DVD) in a storage device, said storage device having a first and a second cover pivotally connected, and having an authentication means, the method comprising the steps of:

positioning an authentication means comprising a printing having authentication information unique to the individual CD or DVD to be stored in said storage device in a mold for injection molding one of said first and second covers such that said authentication means provides a surface against which injected plastic is molded;

injection molding transparent plastic against or around said authentication means in said mold, such that said authentication means cannot be removed from said first or second cover without damaging said authentication means and/or said first or second cover; and

loading said CD or DVD in said storage device, wherein said printing and said CD or DVD is visible through said first or second cover.

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70. (Previously Presented) A method according to claim 69, further comprising providing an electronically readable form related to said data on said data carrier as said authentication means.

71. (Previously Presented) A method according to claim 69, wherein said printing is introduced into said mold on a carrier.

72. (Previously Presented) A method according to claim 71, wherein said printing further comprises providing a holographic printing.

73. (Previously Presented) A method according to claim 71, wherein said printing further comprises providing a bar-code.

74. (Previously Presented) A method according to claim 69, further comprising providing a mold cavity in said mold for forming a fixing means within said storage device for fixing said plate shaped data carrier in said storage device.

75. (Previously Presented) A method according to claim 74, wherein said mold cavity for forming said fixing means in said first or second cover part is provided for holding a CD.

76. (Previously Presented) A method according to claim 75, wherein said mold cavity further comprises providing a surface for forming resilient fingers in said storage device for holding said data carrier in place.

77. (Previously Presented) A method according to claim 69, further comprising providing a hinge cavity in said mold for forming an integrated one piece hinge between said first and second covers.

Claims 78-82 (Canceled)

83. (Previously Presented) A method according to claim 46, further comprising stretching said carrier before or during placement in said mold, such that said carrier is pulled taut.

Claims 84-87 (Canceled)

88. (Previously Presented) A method for manufacturing a storage device for a compact disc (CD) or a digital video disc (DVD), the storage device having a first and second cover pivotally connected, and having an authentication element, the method comprising the steps of:

positioning a printer head adjacent a surface of an injection mold;  
providing a transfer ink directly on said mold surface with said printer head, said transfer ink comprising authentication information unique to the individual CD or DVD to be stored in said storage device; and  
injection molding plastic against said mold surface, wherein said ink printing is transferred from said mold surface onto said plastic and is incorporated therein to form said authentication element.

89. (Previously Presented) A method according to claim 46, wherein said plate shaped data carrier is a compact disc (CD) or a digital video disc (DVD), and wherein said authentication means comprises authentication information unique to the individual CD or DVD to be stored in said storage device.

90. (Previously Presented) A method according to claim 46, wherein said storage device is injection molded in one piece.

91. (Previously Presented) A method according to claim 88, wherein said storage device is injection molded in one piece.

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92. (Previously Presented) A method according to claim 88, wherein said authentication information comprises a holographic printing.
93. (Previously Presented) A method according to claim 88, wherein said authentication information comprises a bar-code.
94. (Previously Presented) A method according to claim 88, wherein said authentication information is magnetic and/or electronic.
95. (Previously Presented) A method according to claim 88, further comprising providing a mold cavity in said mold for forming a fixing means within said storage device for fixing said plate shaped data carrier in said storage device.
96. (Previously Presented) A method according to claim 95, wherein said mold cavity for forming said fixing means in said first or second cover part is provided for holding a CD.
97. (Previously Presented) A method according to claim 95, wherein said mold cavity further comprises providing a surface for forming resilient fingers in said storage device for holding said data carrier in place.
98. (Previously Presented) A method according to claim 95, wherein said mold further comprises forming the first and second covers in one piece with an integrated hinge to allow for a one piece storage device.
99. (Previously Presented) A method according to claim 98, further comprising providing a hinge cavity in said mold for forming an integrated one piece hinge between said first and second covers.

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100. (Previously Presented) A method according to claim 97, wherein said plastic further comprises providing said plastic for injection molding with a melt of at least 30.

101. (Previously Presented) A method according to claim 97, wherein said plastic further comprises providing said plastic for injection molding with a melt of at least 50.

102. (Previously Presented) A method according to claim 88, wherein said injection molding plastic further comprises forming a transparent first or second cover for viewing said authentication means.

103. (Previously Presented) A method according to claim 102, wherein said authentication means further comprises providing a two-sided printing that is viewable from an inside surface and an outside surface of said first or second cover part.

104. (Previously Presented) A method according to claim 88, further comprising providing an electronically readable form related to said data carrier as said authentication means.